

Work Order ID 72386-2

Monday, July 25, 2011 9:17:18 AM

Split-3



Page 1

Item ID: D4360-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00



Required Date: 8/2/2011 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 7/27/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4360

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4360-1)

7/24/11 06:30

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAH

0.00



QC

Memo

0.00

Quality Control

131-8 9

131-8 9

131-8 9

Work Order ID 72386

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Page 2

Item ID: D4360-041

Accept



Setup Start



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Item Name: Wearplate Assembly

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Start Date: 7/25/2011 Start Qty: 8.00



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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

0.00



Large Fab

Memo

0.00

Large Fab

1- Weld cups as per dwg

A/R S.S. ROD BATCH: M114589

2- Apply hardfacing on wearplate as indicated on dwg

A/R HARDCOAT 2059B BATCH: M120645 x

EL 12-2-16

(X2)

140

QC5- Inspect part completeness to step on W/C

0.00



QC

Memo

0.00

Quality Control

8.7/07/16

(12)

Work Order ID 72386

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Page 3

Item ID: D4360-041

Accept

Revision ID:

Item Name: Wearplate Assembly

Start Date: 7/25/2011 Start Qty: 8.00

Required Date: 8/2/2011 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: 256

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PC 12.02.16

2x

12/2/16

M.C.J 12/02/17

12-02-16

Picklist Print

Monday, July 25, 2011 9:17:44 AM

Page 1

Work Order ID: 72386

Parent Item: D4360-041

Parent Item Name: Wearplate Assembly



Start Date: 7/25/2011

Required Date: 8/2/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERE:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S166A

Purchased

No

109

sf

219.4000

0.97867

8.241432

14

B(1-2-4)



304/316 Sheet 063

Location

Loc Qty

Loc Code

MAT020

19.4

117275

1.7

117653

17.7

MAT021

200

118217

200

118217

D4379-1

Manufactured

No

130

Each

0.0000

12

96



Wearplate Cup

~~72386 x 57~~



101 12-1-1

B 61717 x 1

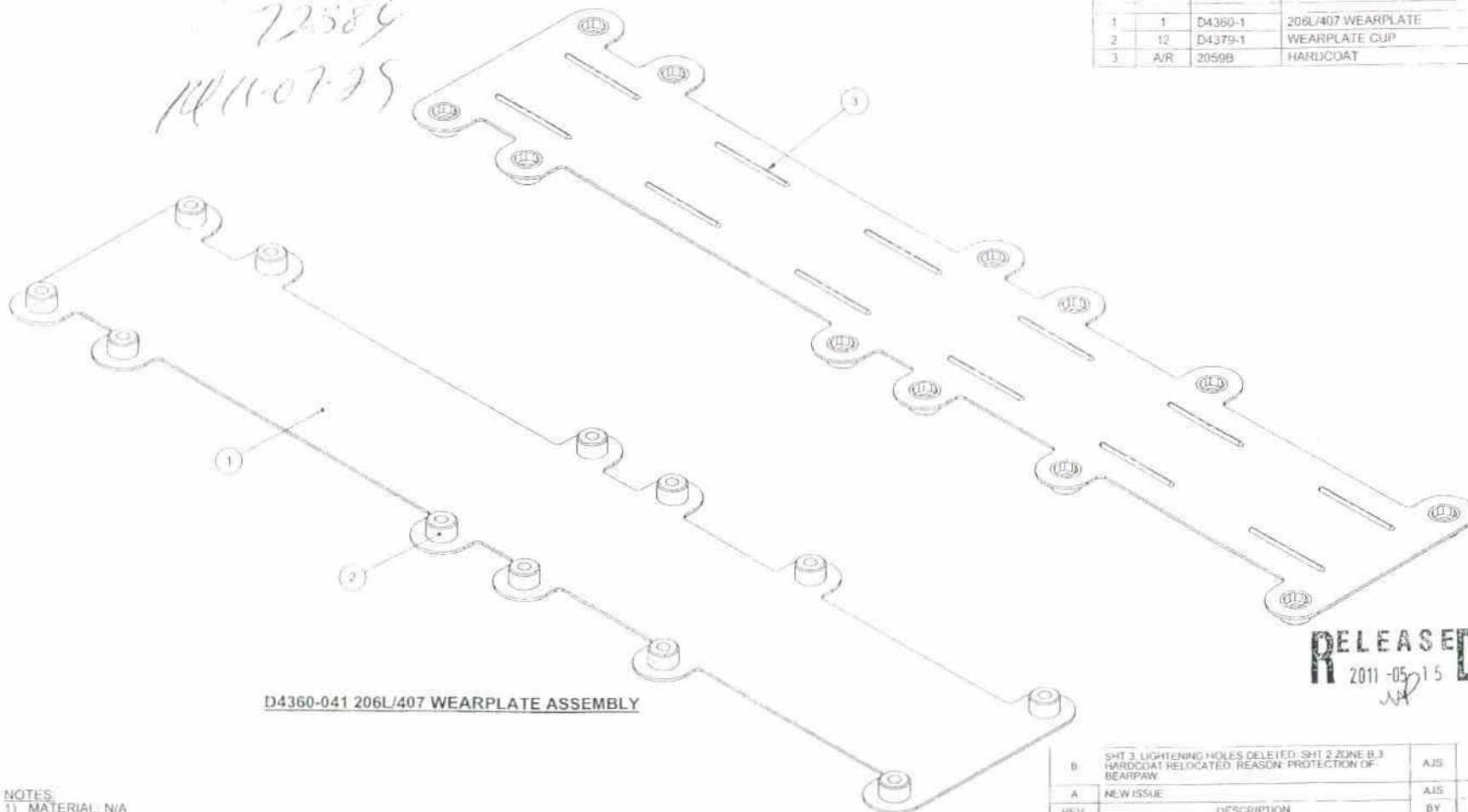
22 12-1-30

72388 x 24 R 12-216

D4360 1

72584
11-07-25

ITEM	QTY	P/N	DESCRIPTION
	041		
	X	D4360-041	206L/407 WEARPLATE ASSEMBLY
1	1	D4360-1	206L/407 WEARPLATE
2	12	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D4360-041 206L/407 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4360-041" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.10 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD: 12 PL

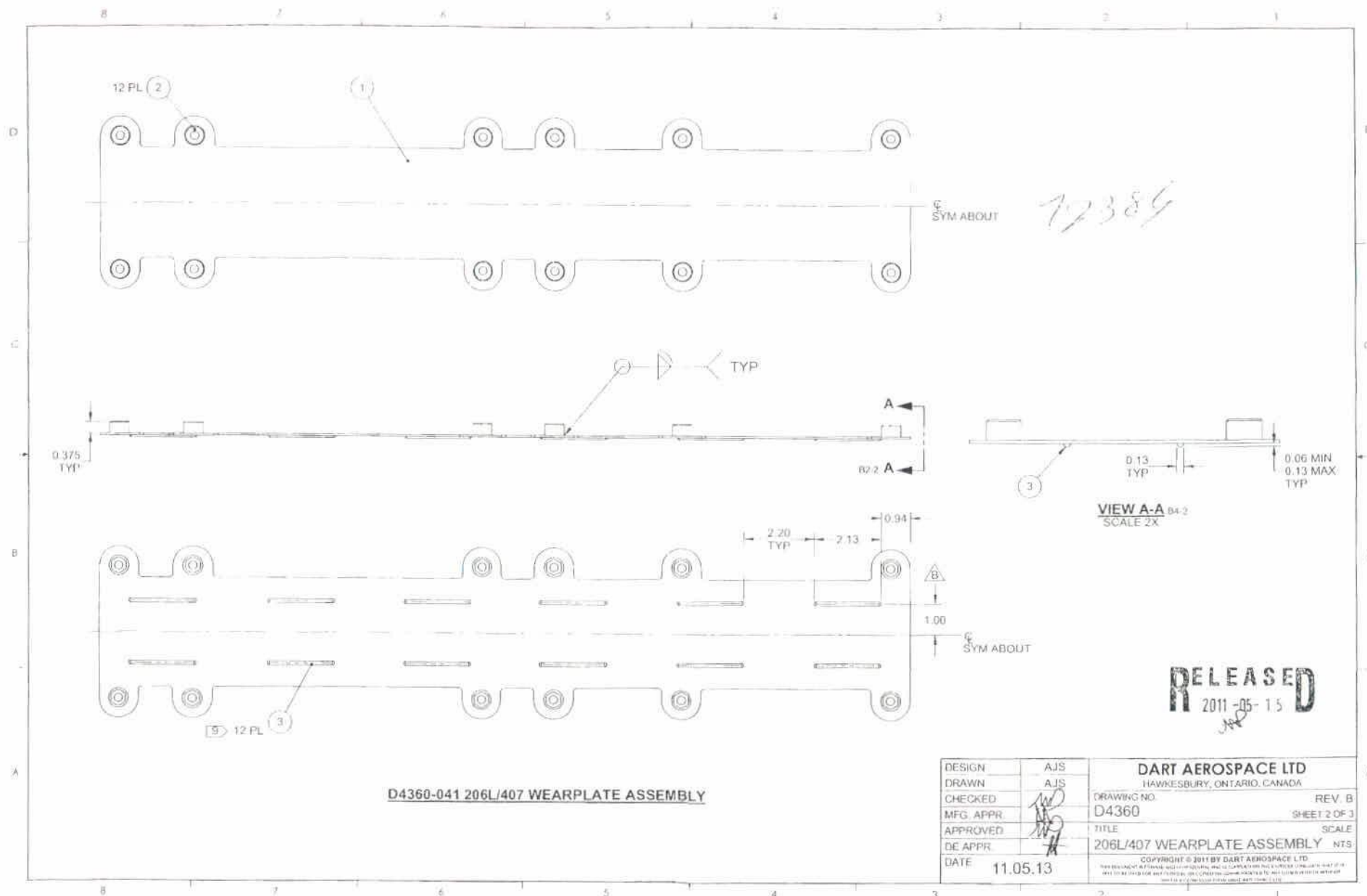
RELEASED
2011-05-15

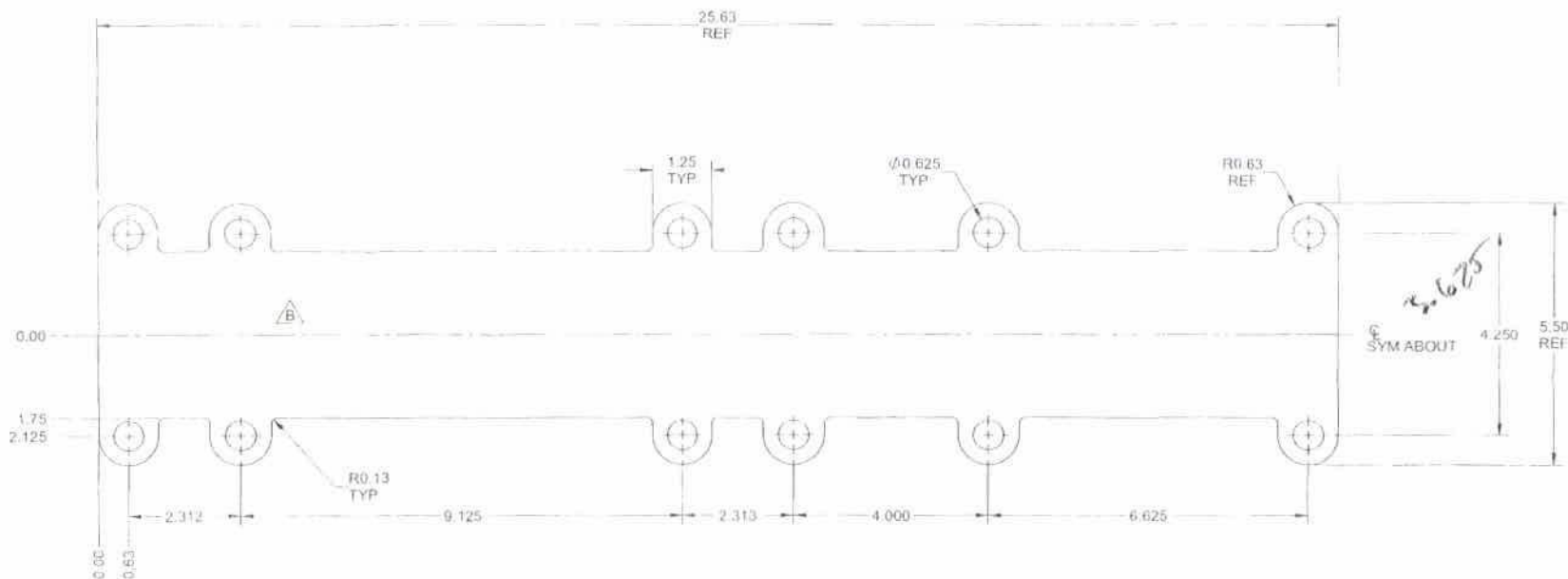
B	SHT 3 LIGHTENING HOLES DELETED, SHT 2 ZONE B.3 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW	AJS	11.05.13
A	NEW ISSUE	AJS	11.03.22
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	11.05.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4360
REV. B
SHEET 1 OF 3
SCALE
TITLE 206L/407 WEARPLATE ASSEMBLY NTS

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D4360-1 206L/407 WEARPLATE

RELEASED
2011-05-15
NR

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV B
MFG APPR	<i>[Signature]</i>	D4360	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	206L/407 WEARPLATE ASSEMBLY	NTS
DATE	11.05.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD	